

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002542**Date Inspected:** 22-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the skin plates splices weld joint # ESD1/SA107 B/J-16A, ESD1/S77 A/E-43 B and ESD1-SA77 A/E-33. The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL\_6027 generated on this date.

The QA inspector assisted Task Leader David McClary performing ultrasonic testing (UT) with the phased array (PA) unit at the deck panel # DP-057-001. Deck Panel DP-057-001 would be used for mechanical test according with ABF representatives. ABF representative Steve Lawton was present during the test. Caltrans representatives evaluated welds # 5 and 6 looking for indications that replicated the indications identified as horse shoes. On deck panel DP-057-001 were found horse shoes indications in 8 tack welds locations. In weld # 1, three other locations were identified as tack welds without the presence of the horse shoes indications. Three other locations were tested outside of the tack areas where not relevant indications were found. The 14 locations above identified are going to be selected as part of the mechanical test by ABF

**Summary of Conversations:**

The QA inspector did not have a relevant indication on this date.

**Comments**

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## WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer